

Work Order ID 57708

April 14, 2010 10:09:08 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

Start Date: 14/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

BP

Date: 10-11-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG0012 ~~10.04.28~~

8.06.10 @ CHG001

8.06.10 @ CHG001

HJ for BG 10/05/11

110

0.00



Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R ☐ Aluminum Rod *1111311*

3-Grind End Plate flush *1114242*

10.04.26

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57708

April 14, 2010 10:09:08 AM



Page 2

Item ID:	D350-591-311	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Access-Step, Long LH					
Start Date:	14/04/2010	Start Qty:	12.00		Cust Item ID:	
Required Date:	22/04/2010	Req'd Qty:	12.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				12	0	BE10/05/04	
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							8.10.05.04
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12	0		10.05.04

Handwritten circled notes: +12, 4H

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57708

April 14, 2010 10:09:08 AM



Page 3

Item ID:	D350-591-311	Accept		Setup	Start	
Revision ID:						
Item Name:	Heli-Access-Step, Long LH				Stop	
Start Date:	14/04/2010	Start Qty:	12.00			
Required Date:	22/04/2010	Req'd Qty:	12.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
180 Large Fab Large Fab	Large Fab Memo 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R <input type="checkbox"/> Aluminum Rod <u>m112860</u> 6-Grind End Plate flush 7-Install last rivet as per Dwg.	0.00 0.00							

Handwritten: = 7m-h w/05/04 (12X)

Handwritten: 12 of 17
10.05.08

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 57708

April 14, 2010 10:09:08 AM



Page 4

Item ID:	D350-591-311	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Access-Step, Long LH					
Start Date:	14/04/2010	Start Qty:	12.00		Cust Item ID:	
Required Date:	22/04/2010	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				12	0	BE 10/05/10	
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(12)			CH
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12		10-5-10	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____








NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				




NOTE: Date & initial all entries

April 14, 2010 10:09:08 AM



Page 5

Item ID:	D350-591-311		Accept		Setup	Start	
Revision ID:							
Item Name:	Heli-Access-Step, Long LH					Stop	
Start Date:	14/04/2010	Start Qty: 12.00		Cust Item ID:			
Required Date:	22/04/2010	Req'd Qty: 12.00		Customer:			
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat								
	Powder Coating								
	Memo	0.00							
	START TIME: 1:45pm								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 2:15pm								
230 	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
	HandFinish								
	Hand Finishing								
	Memo	0.00							
240 	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control								
	Memo	0.00							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57708

April 14, 2010 10:09:08 AM



Page 6

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 14/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-5-11 120 SD

260

QC4- 100% Inspect kits for completeness

0.00



QC

(Did not put hole in.)
8/10/12

Memo

0.00

Quality Control

712
LM

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location:

B

12/10/12 12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57708

April 14, 2010 10:09:08 AM



Page 7

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 14/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/13 AJ

MF

10-5-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:09:12 AM

Page 1

Work Order ID: 57708

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH


Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3065-041		Manufactured	No			180 AA	Each	12.0000	12.0000			
												
Step Leg Assembly Hi											12 10.05.04	

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 356827 12
55450 12

D3066-1



Spacer

Manufactured No

180 AA

Each 40.0000 24.0000



12 10.05.06

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 851920 40
56752 40

D3219-1



Plate

Manufactured No

110 AA

Each 61.0000 24.0000



8 16 10.04.26

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 56826 61
56826 61

24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:09:12 AM

Page 2

Work Order ID: 57708

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH



Comments: IPP Rev:A ☐ 04.03.22 ☐ New issue ☐ KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM ☐
 IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3067-1		Manufactured	No			110	Each	21.0000	12.0000			
												
End Plate												

10.04.26

Warehouse
Location

Main Warehouse

WA

57011

Loc Qty

Loc Code

21

21

110

Each

0.0000

12.0000

12

B 57848 10.04.19 = 12

D3272-1



Step

MS21042L5

x2

Manufactured

No

Purchased

No

110 250 M

Each

360.0000

24.0000

10-5-21

SL (12x)

Warehouse

Location

Main Warehouse

ST300

Loc Qty

Loc Code

360

113523

26

113537

134

114108

200

24

April 14, 2010 10:09:13 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:09:13 AM

Page 3

Work Order ID: 57708

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH




Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS20600-AD4W4		Purchased	No			180 250 M 180	Each	927.0000	192.0000		10.05.06	
												
Rivets												
<div><div>Warehouse</div><div>Location</div><div>Main Warehouse</div><div>ST321</div><div>113368</div><div>114181</div><div>260</div><div>250 M</div><div>927</div><div>427</div><div>500</div><div>22.0000</div><div>24.0000</div><div>173</div><div>19</div><div>10.5.11</div></div>												
AN3-35A		Purchased	No			260	Each	22.0000	24.0000			
												
Bolt												
<div><div>Warehouse</div><div>Location</div><div>Main Warehouse</div><div>ST353</div><div>112314</div><div>260</div><div>250 M</div><div>22</div><div>22</div><div>101.0000</div><div>96.0000</div><div>24</div><div>13x</div><div>83</div><div>1000</div><div>M114495</div><div>M114523</div></div>												
AN4-13A		Purchased	No			260	Each	101.0000	96.0000			
												
Bolt												
<div><div>Warehouse</div><div>Location</div><div>Main Warehouse</div><div>ST357</div><div>114181</div><div>114330</div><div>4828</div><div>101</div><div>6</div><div>88</div><div>7</div></div>												

250 M

Each

22.0000

24.0000

173

19

10.5.11

April 14, 2010 10:09:13 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:09:13 AM

Page 4

Work Order ID: 57708

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH


Comments: IPP Rev:A ☐ 04.03.22 ☐ New issue ☐ KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM ☐
 IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN936A 		Purchased	No			260 250 AA	Each	149.0000	24.0000		10-5-11 SP	
Bolt												

Warehouse
Location

Main Warehouse

ST341

114292

Loc Qty

149

149

Loc Code

260
250 AA

Each

0.0000

48.0000

260
250 AA

Each

0.0000

192.0000

260
250 AA

Each

0.0000

48.0000

260
250 AA

Each

123.0000

48.0000

Warehouse

Location

Main Warehouse

ST476

56855

Loc Qty

123

123

Loc Code

4E

M114292 10-5-11 SP

89 M113706 M114576 10-5-11 SP

M113706 M114576

M113706 10-5-11 SP

10-5-11 SP (120)

April 14, 2010 10:09:13 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:09:13 AM

Page 5

Work Order ID: 57708

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2618		Manufactured	No			260 250 AA	Each	33.0000	24.0000	8x		
Bushing											357829 10-5-11	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST020

56892

33

33

f

308.9400

7.2000

16

10-5-11

D2856-400



Abraison Strip

Manufactured

No

measured
Dider 12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

50593

56626

308.94

92.94

216

Each

21.0000

12.0000

2.1x

10.05.08

D3067-1



End Plate

Manufactured

No

260
180 AA

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

357926

57011

21

21

12

April 14, 2010 10:09:13 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:09:13 AM

Page 6

Work Order ID: 57708



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 14/04/2010

Required Date: 22/04/2010

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3235-1		Manufactured	No			260 250 AA	Each	23.0000	24.0000	1351921	10-5-11	sf
Mounting Lug												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST471

23

55315

23

Each

23.0000

12.0000

7

10-5-11

sf

D3278-041



Support Assembly

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST471

23

55318

23

Each

1,201.000

24.0000

12

10-5-11

sf (124)

MS21042L3



Nut

Purchased No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1201

113537

217

113644

984

24

April 14, 2010 10:09:13 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:09:13 AM

Page 7

Work Order ID: 57708

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L4	X6	Purchased	No			260 250 M	Each	1,362.000	96.0000	19		



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST139

2

111827

2

Main Warehouse

ST300

1360

113422

368

114108

984

9063

8

M114416 10-5-11 SD
M114523 (7X) (12V)

April 14, 2010 10:09:13 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07 06 04 H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A REWORK
WITHOUT NOTICE
WORK ORDER
NO. *57708*

MS10-4-14

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

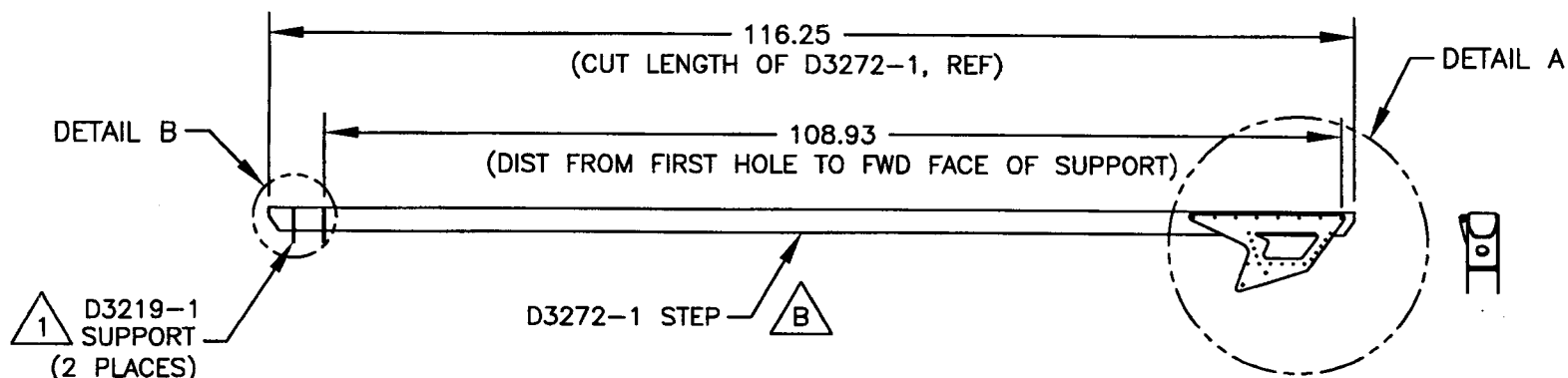
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

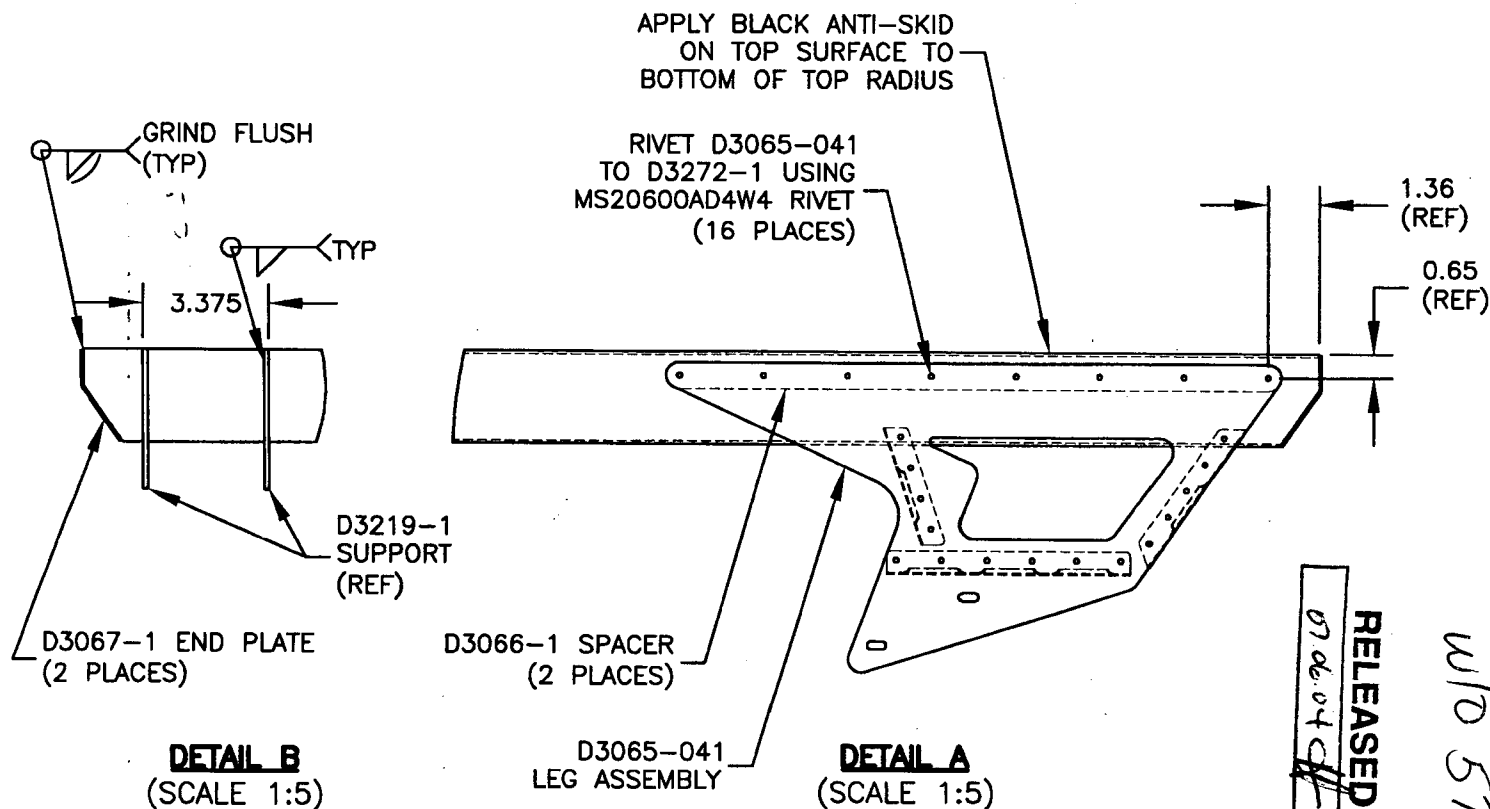
NOTE: Date & initial all entries

DART

DESIGN	90	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	D3272	REV. B
		STEP ASSEMBLY, HI LONG		SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2004 by DART AEROSPACE LTD

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

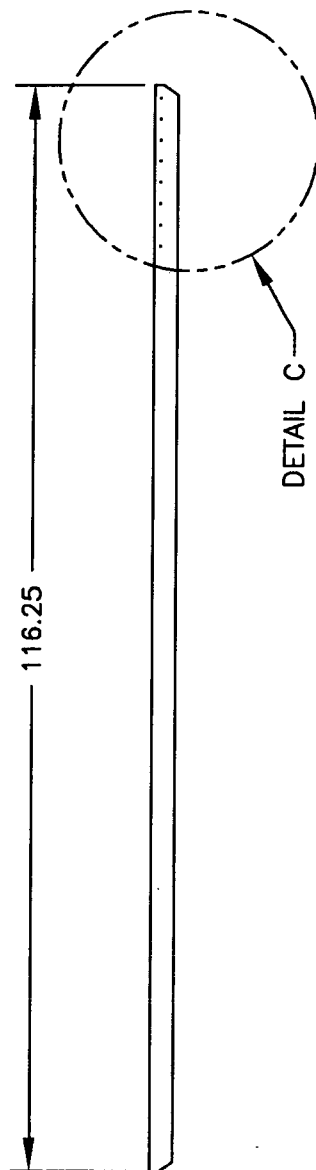


DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

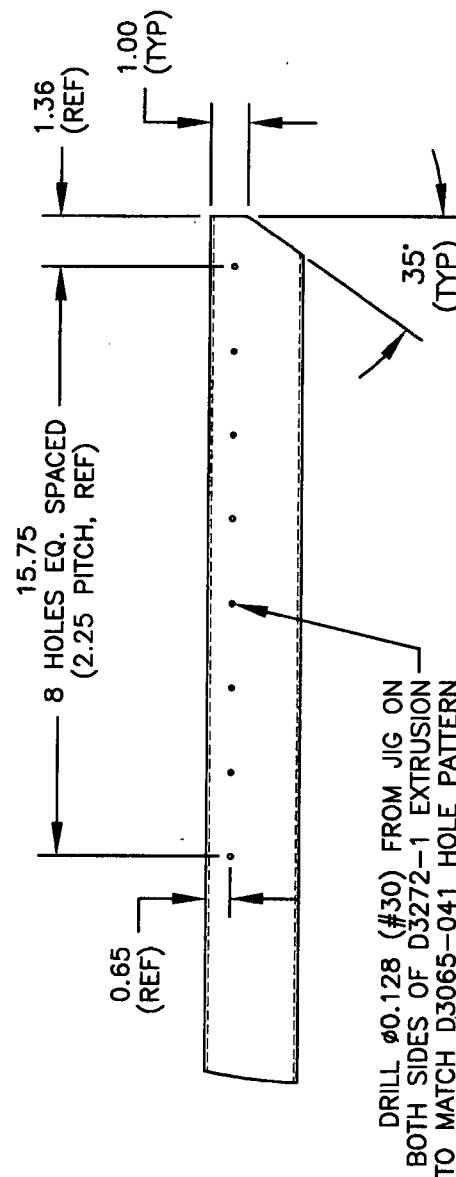
wlo 57708

RELEASED

07.06.04 *[Signature]*



B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD.

REFERENCE ONLY

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step - High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step - High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step - High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step - High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step - Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step - Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step - High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step - High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
			2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4							D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-100-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
			4	4	4	8	8	AN7-13A	BOLT
						2	2	AN3-36A	BOLT
4	4	4	4	4	4	4	4	AN9603B10	WASHER
20	20	12	12	12	12	16	16	AN9603D416	WASHER
						4	4	AN9603D516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

• COPYRIGHT © 1993 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G
Date: 08.10.06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries